

Date: Monday, 4/30/2007 7:23:05 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT
Job Number	: 32102		
Estimate Number	: 10532		
P.O. Number	: <i>N/A</i>	Part Number	: K10003
This Issue	: 4/30/2007 S.O. No. : <i>N/A</i>	Drawing Number	: K10003
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31218	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/20/2007
Checked & Approved By	: <i>[Signature]</i>		
Comment	Est: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est: J 06-07-25 As per DSI 9344 JLM Est: K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ		

Qty: *10* Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 288.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	<i>B30811</i>

X

3.0	D2571	Saddle, Fwd, Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	<i>B32076</i>

green

X

7/5/24 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE KIT

Job Number: 32102

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty

Part Number

Description

Batch

1

D2572

Saddle

green
B32077 X

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty

Part Number

Description

Batch

1

D2573

Saddle

green
B32078 X

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Aft, In

Pick:

Qty

Part Number

Description

Batch

1

D2574

Saddle

green
B32079 X

7.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D2736-1

Bracket

B31225 X

8.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D2736-3

Bracket

B30853 X 7/5/24 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: SADDLE KIT

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Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description
4	D2747	Socket Head Set Screw

Batch

10 1
B30818

29
31300

X

10.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description
2	D2876	Spacer

Batch

17
B28046

31227

X

11.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description
2	D2877	Spacer

Batch

M30055

X

12.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description
1	D2968-041	Tow Ring

Batch

B29791

X

13.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Batch:

B28093

X

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bolt

Pick:

M102115

X

7/5/24 58

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

15.0 AN446A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-6A	Bolt	

(10) in stock (30) ✓
M102985, M103962

16.0 AN451A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	

M103684, ✓

17.0 AN612A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	

(9) * (10) * (61) ✓
M102809 M103287 103915

18.0 AN960JD416 Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 384.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	

M103691 ✓

19.0 AN960JD616 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	

16 in a stock * ✓
M103395 ✓ 17/05/24 SQ

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	M103344

21.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 348.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
29	MS21042L4	Nut (or MS21042-4)	M102552

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: REV: H

24.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 87-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

32102

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